

# Work Order ID 64362

Thursday, December 02, 2010 1:49:20 PM



SHIP DEC

Page 1

Item ID: D350-607-417

Accept



Setup Start



Revision ID:

Item Name: Lightweight Lid Installation (Long)

Stop



Start Date: 12/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 10-12-02

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-607-2

C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-417 CHG002

*Swins*

*10-12-8*  
*①*

104

0.00



Small Fab

Memo

0.00

Small Fab

Assemble lid as per dwg D4032 sheet 3 of 3, section C-C, view F-F.

*10/12/08*  
*①*

106

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*10/12/08/ML*

*10/12/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64362**

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SHIP 8/12

Page 2

Item ID: D350-607-417

Accept



Setup Start



Revision ID:

Stop



Item Name: Lightweight Lid Installation (Long)

Start Date: 12/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 10-12-02 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/12/3

SC

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8.00/12/3

Q

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DD350-607-417

Location:

PPP rev: A

10/12/9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 64362**

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Setup Start

Revision ID:

Stop

Item Name: Lightweight Lid Installation (Long)

Start Date: 12/2/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/09 [Signature]  
MF  
10-12-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 1

**Parent Item Name:** Lightweight Lid Installation (Long)

**Required Date:** 12/8/2010

**Required Qty: 1.00**

**Comments:** IPP REV: A NEW ISSUE JLM 10-04-15 VERIFIED BY:DD IPP Rev:B  
as per ecn 10-552 DD 10.04.19 verified by:EC IPP REV:C 10.087.26 part  
list chg per ECN 10-596 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-20A  Bolt		Purchased				104	Each	64.0000	2	2		10/12/35	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST352				64					
				105125				24					
				115371				40					
AN5-21A  Bolt		Purchased				104	Each	52.0000	2	2		10/12/35	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST339				52					
				114714				50					
				16463				2					
D2530  Handle Weldment		Manufactured				104	Each	7.0000	1	1		10/12/35	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				7					
				62946				7					
D2535  Spring		Manufactured				104	Each	40.0000	2	2		10/12/35	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				40					
				58331				40					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 64362

Parent Item: D350-607-417

Parent Item Name: Lightweight Lid Installation (Long)

Start Date: 12/2/2010

Required Date: 12/8/2010

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No



Bushing

104

Each

22.0000

2



10/12/35

Location

Loc Qty

Loc Code

ST504

22

62393

22

D4086-215



Placard, Max Load

Manufactured No

104

Each

4.0000

1



10/12/35

PW →

Location

Loc Qty

Loc Code

ST121

4

61128

4

D4086-220



Placard, Max Load

Manufactured No

104

Each

12.0000

1



10/12/35

PW →

Location

Loc Qty

Loc Code

ST112

12

56979

1

58309

11

MS21042L3



Nut

Purchased No

104

Each

1,319.000

2



10/12/35

Location

Loc Qty

Loc Code

ST300

1319

114784

323

115835

996

2

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Shop Packet Print

Page 2

W/O: 64362		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/08	100	Perm. change change to correct picking sequence	[Signature]	10.12.09			[Signature] 10/12/08

Part No: D350-607-417 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 64362

Parent Item: D350-607-417

Parent Item Name: Lightweight Lid Installation (Long)

Start Date: 12/2/2010

Required Date: 12/8/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

104

Each

1,285.000

2

2



Nut



12/12/35

## Location

## Loc Qty

## Loc Code

ST139

26

114813

26

ST300

1259

115156

59

115594

500

116104

200

116105

500

NAS1149F0563P

Purchased

No

104

Each

168.0000

2

2



Washer



12/12/35

## Location

## Loc Qty

## Loc Code

ST298

168

114576

168

D3915-041

Manufactured

No

104

Each

0.0000

1



Light Lid Assembly, Long Basket

D3917-3

Manufactured

No

110

Each

3.0000

6



Washer



EP 10/12/08

12/12/35

64429 x 4

2

## Location

## Loc Qty

## Loc Code

ST095

2

63672

2

ST096

1

57144

1

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 64362

Parent Item: D350-607-417

Parent Item Name: Lightweight Lid Installation (Long)

Start Date: 12/2/2010

Required Date: 12/8/2010

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured No

110

Each

8.0000

Gas Spring Washer

## Location

## Loc Qty

## Loc Code

ST100

6

64258

6

ST103

2

60008

2

AN4-12

Purchased

No

110

Each

16.0000

Bolt

## Location

## Loc Qty

## Loc Code

ST357

16

114292

2

114784

14

AN310-4

Purchased

No

110

Each

63.0000

NUT

## Location

## Loc Qty

## Loc Code

ST324

63

115936

13

116075

50

AN310C4

Purchased

No

110

Each

22.0000

Nut

## Location

## Loc Qty

## Loc Code

ST349

22

114306

22

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64362

Parent Item: D350-607-417

Parent Item Name: Lightweight Lid Installation (Long)

Start Date: 12/2/2010

Required Date: 12/8/2010

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

110

Each

583.0000

3

Cotter Pin

Location

Loc Qty

Loc Code

ST309

583

17566

583

110

Each

38.0000

2

MS24665-300

Purchased

No

Cotter Pin

Location

Loc Qty

Loc Code

ST309

38

110123

38

110

Each

308.0000

2

NAS1149C0432R

Purchased

No

Washer

Location

Loc Qty

Loc Code

ST297

308

114292

50

114742

258

110

Each

196.0000

6

NAS1149F0432P

Purchased

No

Washer

Location

Loc Qty

Loc Code

ST275

196

112940

92

114405

1

114576

10

114718

2

116169

91

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

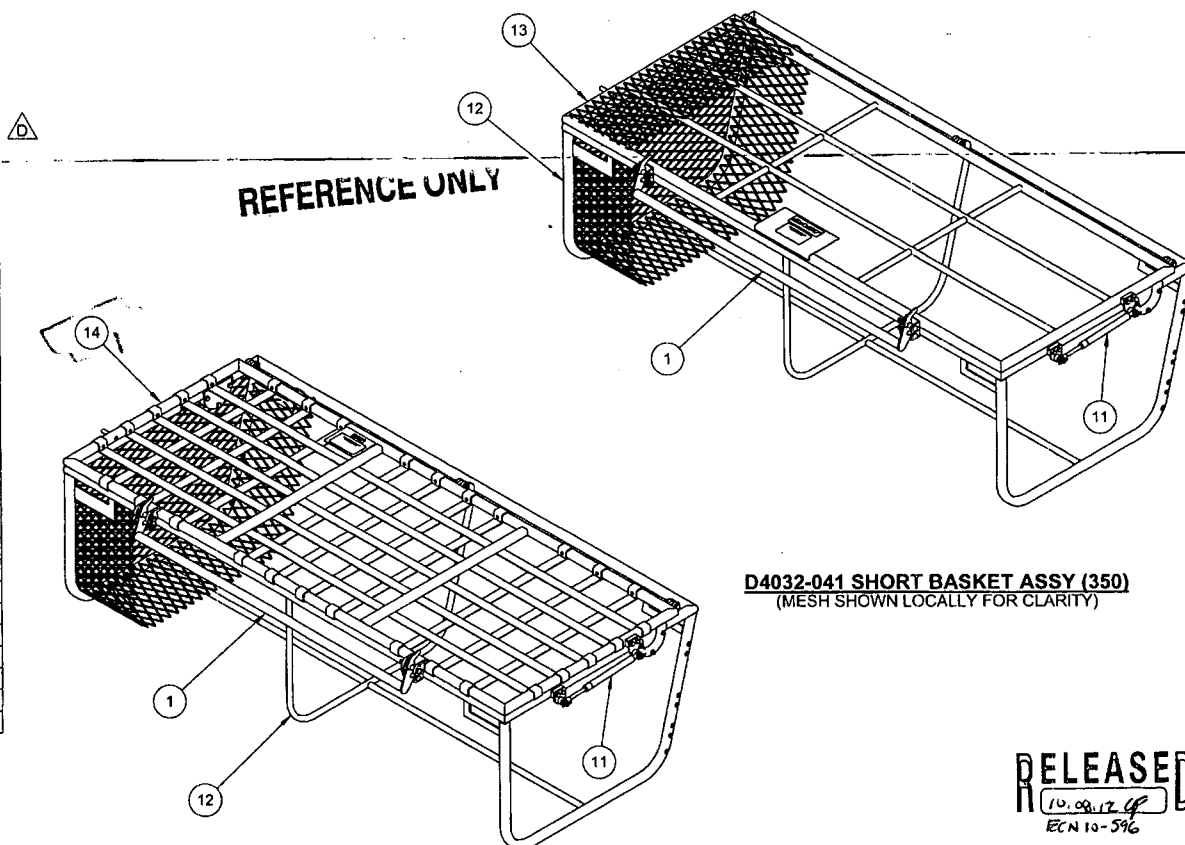
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 56 lbs APPROX  
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DESIGNED		
DRAWN	DRAWN		
CHECKED	CHECKED		
MFG. APPR.	MFG. APPR.		
APPROVED	APPROVED		
DE APPR.	DE APPR.		
DATE	10.07.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

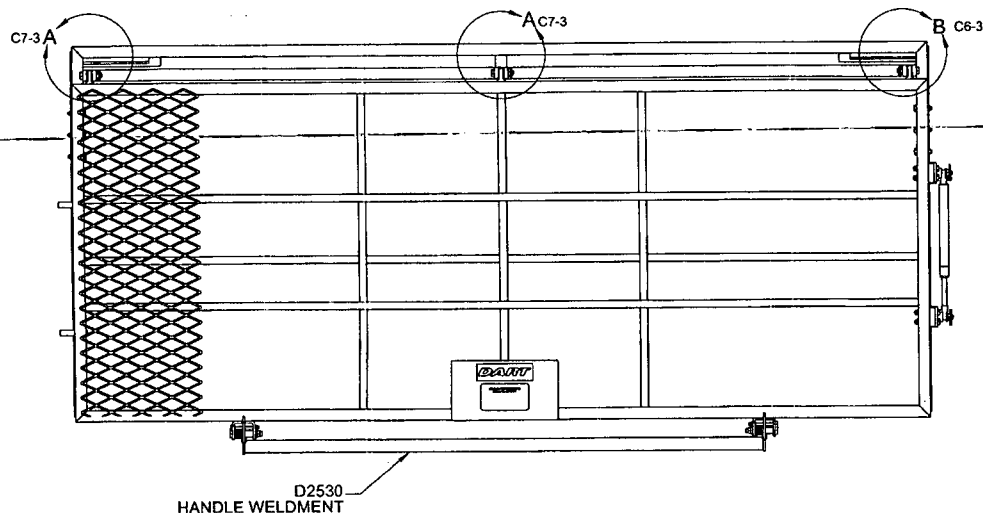
DRAWING NO. **D4032** REV. D  
SHEET 1 OF 3

TITLE **SHORT BASKET ASSY (350)** SCALE  
NTS

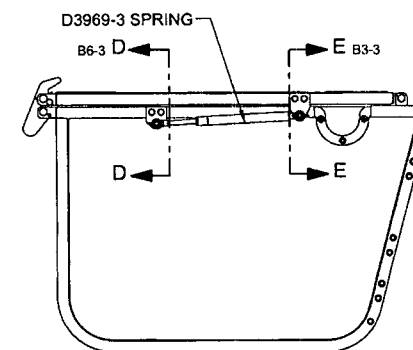
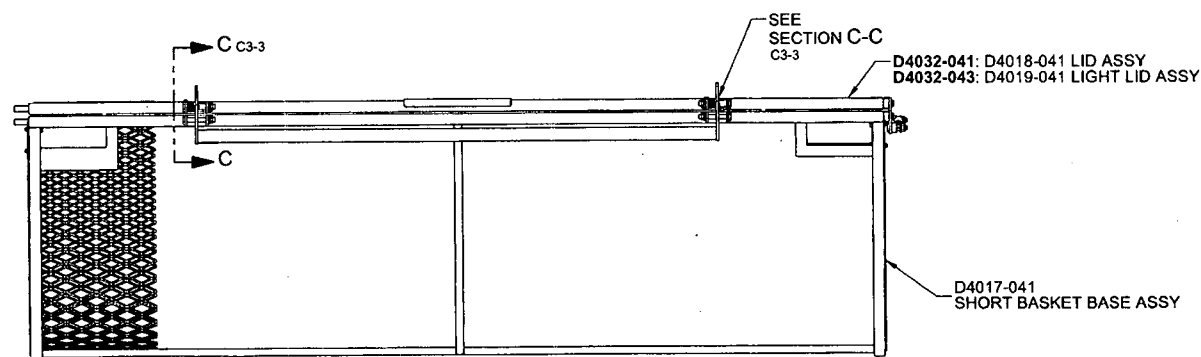
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**RELEASED**  
10.09.17  
ECN 10-596

8 7 6 5 4 3 2 1



REFERENCE ONLY



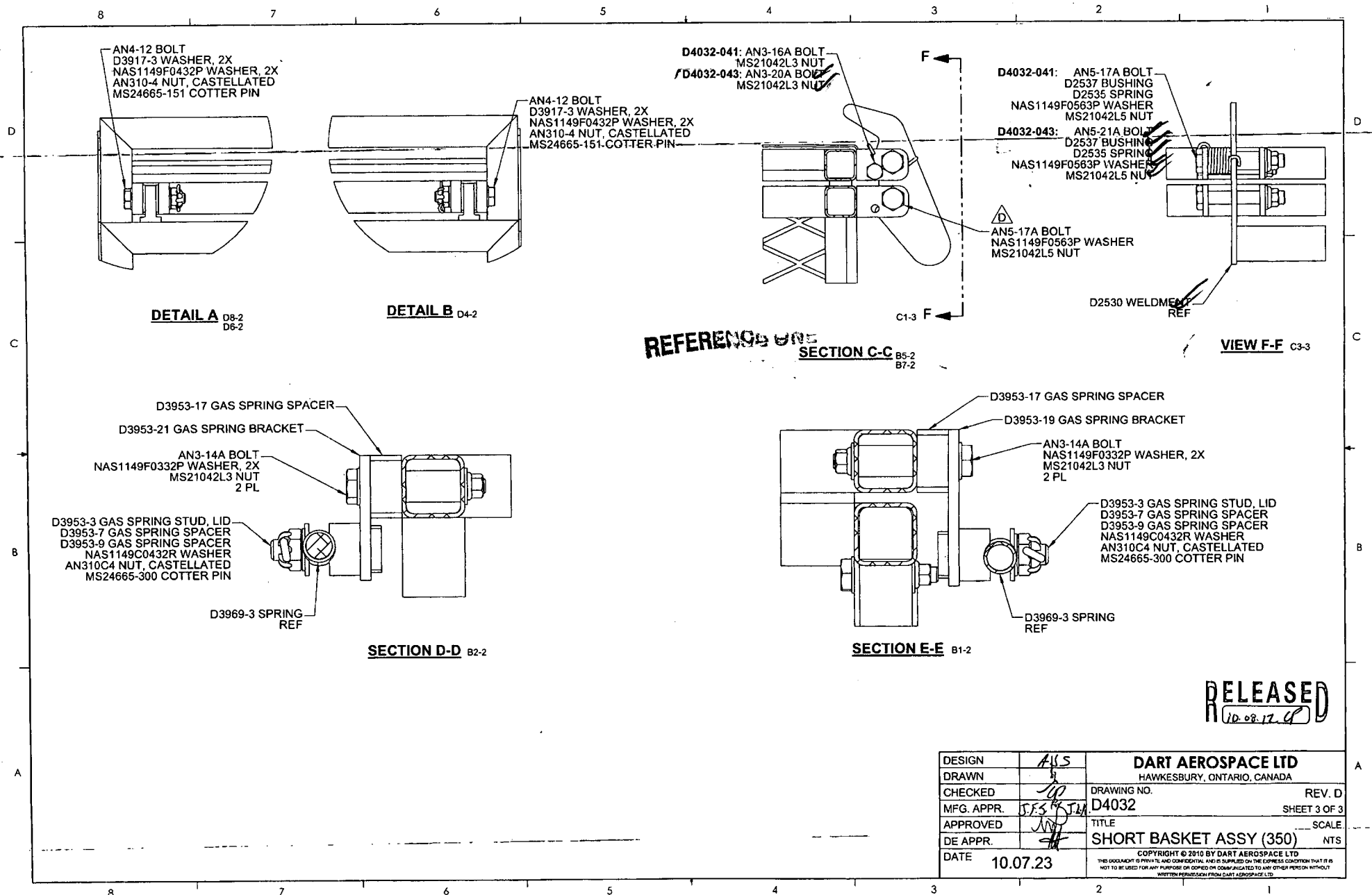
**D4032-041 SHORT BASKET ASSY (350) (SHOWN)**  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

**D4032-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
10.08.12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JFS	D4032	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET ASSY (350) - NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



## 6.0 CONVERSION &amp; OPTIONAL KITS PARTS LIST

QTY -413	QTY -415	QTY -417	QTY -419	QTY -421	PART NUMBER	DESCRIPTION
X		X			D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-421	PROP ARM ASSEMBLY KIT
				1	D2332-041	PROP ARM ASSEMBLY
1	1	1	1		D2530	HANDLE ASSEMBLY
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
1					D3914-041	LONG BASKET LID ASSEMBLY
		4			D3915-041	LONG BASKET LID ASSEMBLY (LIGHTWEIGHT) <i>gus</i>
6	6	6	6		D3917-3	WASHER
1	1	1	1		D3953-9	GAS SPRING WASHER
	1				D4018-041	SHORT BASKET LID ASSEMBLY
			1		D4019-041	SHORT BASKET LID ASSEMBLY (LIGHTWEIGHT)
1					D4086-200	PLACARD, MAX LOAD
1					D4086-210	PLACARD, MAX LOAD
		1			D4086-215	PLACARD, MAX LOAD
	1	1			D4086-220	PLACARD, MAX LOAD
	1		1		D4086-232	PLACARD, MAX LOAD
			1		D4086-243	PLACARD, MAX LOAD
2	2				AN3-16A	BOLT
		2	2		AN3-20A	BOLT
3	3	3	3		AN4-12	BOLT (DRILLED)
				2	AN4-22A	BOLT
2	2				AN5-17A	BOLT
		2	2		AN5-21A	BOLT
3	3	3	3		AN310-4	CASTELLATED NUT
2	2	2	2		AN310C4	CASTELLATED NUT
				4	AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
2	2	2	2		MS21042L5	NUT (OR MS21042-5)
				2	MS21043-4	NUT
3	3	3	3		MS24665-151	COTTER PIN
2	2	2	2		MS24665-300	COTTER PIN
2	2	2	2		NAS1149C0432R	WASHER
6	6	6	6	2	NAS1149F0432P	WASHER
2	2	2	2		NAS1149F0563P	WASHER